



Dart Aerospace Ltd.
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Canada

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D5331-041
Job Sheet 200491



Part No: D5331-041

Job Qty: 1 pcs

Part Name: Basket Base Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Due Date: 10/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEETS 1,2,4,5,6,7,8 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM IPP REV:B 17.03.27 add D4016-7 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	10/4/19		0.00	30.30	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		DAS
							Large Fab - 5		43
							Large Fab - 6		9-89
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	10/4/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		DAS
							QC 9 - 24		24
							QC 9 - 43		9-89
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1	10/4/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		DAS
							QC 5 - 24		24
							QC 5 - 3		9-89
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 56		
							QC 5 - 68		



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Container No: S220043



Part: D5331 - 041

Job No: 200491

Serial No/Batch: S220043

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/05/19

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						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
125	Handfinish - 2-1 Pressure- B4B	1	10/4/19	0.00	2.34	Handfinish - 2 - 1 - B4B	
	pcs					Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	BK 14-10-9.
						Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White Gl(S)- B4B	1	10/4/19	0.00	0.53	Powdercoat - 1 - B4B	
	pcs					Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BK 14-10-9.
						Powdercoat - 4 - B4B	
140	QC 3	1	10/4/19	0.00	0.00	QC 3 - 10	
	pcs					QC 3 - 13	
						QC 3 - 15	HL 14-10-9.
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	1	10/4/19	0.00	0.00	Packaging 3 - 1 - B4B	
	pcs					Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 -	HL 14-10-9.

					B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180	QC 21 - SA	1	10/4/19	0.00	0.00	QC 21 - SA - 21
		pcs				QC 21 - SA - 70
						QC 21 - SA - 53

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: 4139022) 4- Assemble ribs and weld as per dwg D5331 using DT10197
 Descriptions: ***Inspect before welding mesh*** (54.63 CRITICAL DIMENSION)*** 2- Weld gusset and handle plate as per dwg 3-
 Cut mesh as per dwg D5328-1 4- Tack weld mesh on basket as per dwg D5331 and trim mesh to fit if necessary and trim
 to clear fasteners holes on the ends 5- Weld hinge (6) and Mounting brackets (2) as per dwg D5331 ***Take lid to locate
 hinge and bracket*** ***On one of the hinge weld stopper D4016-7 as per dwg*** 6- Weld D5325-5 foot as per dwg
 (CRITICAL)
 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O)
 125 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)
 130 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (6) prior to powder
 coat 1ST COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
 *****2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 140 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5211240
D3913-15 ✓	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5184576
D3916-5 ✓	Light Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5211960
D4016-1 ✓	Hinge Half, Base	6 pcs (6 ea)	100-Large Fab - Basket - 1	5213354
D4016-7 ✓	Stop	1 pcs (1 ea)	100-Large Fab - Basket - 1	5097165
D4021-1 ✓	Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5211134
D5325-041 ✓	Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5150825
D5325-3 ✓	Light Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5192226
D5325-5 ✓	Foot	4 pcs (4 ea)	100-Large Fab - Basket - 1	5214754
D5326-041 ✓	Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5126564
D5326-043 ✓	Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5192445
D5327-1 ✓	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5138436
D5327-11 ✓	Rib	4 pcs (4 ea)	100-Large Fab - Basket - 1	5101863 52135852
D5327-13 ✓	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5067675
D5327-15 ✓	Cap	1 pcs (1 ea)	100-Large Fab - Basket - 1	5108289
D5327-3 ✓	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5127015
D5327-5 ✓	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5127616
D5327-7 ✓	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5127694
D5327-9 ✓	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5127080
D5328-3 ✓	Mesh Base, Aft	1 pcs (1 ea)	100-Large Fab - Basket - 1	5144989
D5328-5 ✓	Mesh Base, Fwd	1 pcs (1 ea)	100-Large Fab - Basket - 1	5118091
D5329-1 ✓	Gusset	2 pcs (2 ea)	100-Large Fab - Basket - 1	5210739
D5330-1 ✓	Handle Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5209380
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5206463

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	87	0
	D3913-15	1	34	0
	D3916-5	2	31	0
	D4016-1	6	7	0
	D4016-7	1	5	0
	D4021-1	1	94	0
	D5325-041	1	0	0
	D5325-3	1	0	0
	D5325-5	4	0	0
	D5326-041	1	4	0
	D5326-043	1	2	0
	D5327-1	1	1	0
	D5327-11	4	2	0
	D5327-13	1	4	0
	D5327-15	1	9	0
	D5327-3	1	0	0
	D5327-5	1	0	0
	D5327-7	1	0	0
	D5327-9	2	0	0
	D5328-3	1	4	0
	D5328-5	1	2	0
	D5329-1	2	6	0
	D5330-1	2	14	0
	M304EX0.75-16F	32	883	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: _____